											47 10	4
Work Order Tuesday, July 24, 2				*88	N26*					hip	Page 1	V
Revision ID:	9407-559-115 earpaw			Accept	*N900	040°	100)* s	etup Star Stop	1/1	S1* S2*	
Start Date: 7/ Required Date: 7/ Reference:		Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item l Customer:	D:				14		
	Process Plan:	MF	Date:\ <u>\(\rangle\)-\(\rangle\)-\(\rangle\)</u>			ate:		R	un Star Stop	, , , , , , , , , , , , , , , , , , ,	R1* R2*	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty\	Reject Qty	Reject Number	Insp.	
Draw Nbr	Revisi	on Nbr										
DSI 9624	REV A	Λ										
*100 *100* DC Document Control	С	OOCUMENT CONTRO Memo Photocopy b	olue file and type labels pe	0.00 0.00 r PPP D407-559-115	CHGOOI JB					<i>м</i> с ³	12/08	4.80
*151 *151* Packaging Packaging	P	ick Kit Memo		0.00				<u>/-1.</u>	447)		
160	C	0C4- 100% Inspect kits	for completeness	0.00 DA	S v ((
160 QC Quality Control		Memo		0.00	री००७							

				DQA:	Date:	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE			

									QA Closed:	Date	:			
Work Orde	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. Scrap Use-as-is Work Order Update			1 1	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other						
Root				Descri	ption of work order update	Initial	Act	tion	Sign &					
Cause	Date	Step	Qty	•	or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector			
Doc/Data														
Equip/Tooling										•				
Operator														
Material [
Setup														
Other						5.7								
Process [6.								
Supplier [
Training														
Unapproved														
						AULT CATE	GORY							
Landin	g Gear				General						_			
	Bending				Bend	Grain			Ovalized		Pressure/Forced			
	Centre No	ot Concei	ntric to (D/S	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure			
	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld			
	Crushed/	Crimped.			Burrs	Instruc	tions Incomplete/I	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
	Cuffs				Contamination	Maint	enance		Part Moved					
	Heat Trea	it .			Countersink		eled	·	Positioned V	Vrong				
	Inspection	n Strip in	Tube	L	Cut Too Short	Misrea	d		Power Loss/	Surge	Other			
	Ripples in	Bend		L	Drill Holes	Offset					***			
	Torque W			ր _	Drawing	\vdash	Calibration							
0	Turning S	-			Finish	Out of	Sequence							
	Wave/Tw	ist in Tub	e		Folio	Outsid	e Dimensions							

H: JFORMS/Quality Assurance \approved QA/NCRWO Rev G

Work Order ID 88026 Tuesday, July 24, 2012 7:53:21 AM			*88026*								Page 2		
Item ID: Revision ID: Item Name:	D407-559-11	5		Accept	*N900	040	100)* Setu	p Start Stop	*N:	S1* S2*		
Start Date: Required Date: Reference:	7/24/2012 : 7/27/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	D:							
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		te:		Run	Start Stop	*N *N	R1* R2*		
Sequence ID/ Work Center I 170 *170*	D	Operation Description Identify as per dwg & St	ock Location:	Set Up/ Run Hours	Tool ID	Tool #	Plan Code			Reject Number	Insp. Stamp		
Packaging Packaging		Мето	SUPP	0.00									
*180		QC21- Final Inspection	- Work Order Release	0.00					M C C	ナ 又	(08/130)		
QC Quality Control		Memo		0.00					MC	Jnl	60 180		

												DQA:	Date:			
NCR: Y	'es	/ No					WORK ORDER NON-C	COI	NFOR	MANCE / UP	DATE					
						_		-				QA Closed:	Date:			
Work Orde	er:						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Part No				Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing		Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other				
NCR No.			Work Order Update			Large Fab Composite			Supplier							
Root					Des	cri	ption of work order update		Initial	Act	tion	Sign &				
Cause		Date	Step	Qty		(or Non-conformance	Cr	nief Eng	Desci	ription	Date	Verification	QC Inspector		
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rocess																
upplier																
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Inapproved																
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Landir	ıg G	ear					General		_							
		Bending					Bend		Grain			Ovalized		Pressure/Forced		
ļ		Centre No	t Concer	ntric to	o/s		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure		
					Broken/Damaged		Inspecti	on incomplete		Part Incorre	ct	Weld				
	Crushed/Crimped Burrs			Burrs		Instruct	ions Incomplete/I	Unclear	Part Lost/M	issing	Wrong Stock Pulled					
			Contamination		Mainte	nance		Part Moved								
		Heat Treat	t				Countersink		Mislabe	led		Positioned Wrong				
	Inspection Strip in Tube Cut Too		Cut Too Short		Misread			Power Loss/Surge O		Other						
			Drill Holes		Offset											

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:

88026

Parent Item:

D407-559-115

Parent Item Name:

Bearpaw

Start Date: 7/24/2012

Required Date: 7/27/2012

Start Qty: 1.00

Required Qty: 1.00

_		
Cor	nme	nts:

IPP REV:A NEW ISSUE 12-07-23 JLM VERIFIED BY:DD

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit		Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand		Qty	Issued	Issued	:
D2274		Manufactured	No				Each	118.0000		112	1/ 1	0	æ
Radius Block												<u> </u>	
				Location		Loc Qty	<u>L</u>	oc Code					
				ST009		118				0116			
				8634	48	118			_86	348			
D2529		Manufactured	No				Each	486.0000		$\overline{12}$		B	
Washer											7		
				Location		Loc Qty	<u>L</u>	oc Code			.*		
				ST010	o.=	486							
				7948 8 690		18 468			70	909	\sim	802	P- '
D2432-3		Manufactured	No	007	0)	400	Each	0.0000	_ 6 4	2	4	8000	
206 (24") Bearpaw		Manufactured						*******	47		8-1-0		
D4011=1		Manufactured	No				Each	43.0000		6	/ .		
Clamp, Short									<u> </u>		JB_		
				Location		Loc Qty	<u>L</u>	oc Code			0		
1				ST460		43							
				831	63	43			8:	3/63			
D4012-1		Manufactured	No				Each	56.0000		6	/ N A	10	1001
Cushion											- Y D	-1 4	0 17
				Location		Loc Qty	<u>L</u>	oc Code					
				ST459		42			~ 7	1100			
				831	65	42			<u>83</u>	165			
				ST460	40	14							
				698- 732		5 9							

n	ICD.	Voc	1	NIO
Ν	ICR:	Yes	/	No

DQA:

Date:

NCR:	Yes	/ No					WORK ORDER NON-O	COL	NFORM	MANCE	/ UP	DATE				
		,											QA Closed:	Date	·	
Nork Ord	er:	,					DISPOSITION					AGAINST DE	PARTMENT	PROCESS	· •	
	•						Rework]		Skid-tube		Crosstube]	Water Jet	Engineering	ı
Part I	٧o.			,			Scrap		Machining Small Fab				Pro	d. Eng. Coor.	Quality	
							Use-as-is			Thermoforming Finishing Rec/Store/Packaging				Other	١	
NCR No Work Order Update				J	Large Fab Composite Supplier						l					
Root					Des	crip	otion of work order update	Ī	nitial		Ac	tion	Sign &	····		1
Cause		Date	Step	Qty		C	Non-conformance (ief Eng		Desc	ription	Date	Verification	QC Inspector	
oc/Data										·						
quip/Tooling																1
perator																
laterial																
etup																
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raining					İ										,	1
napproved				<u> </u>				<u> </u>	T CATE	COPY					<u> </u>	\dashv
Landi	nø (Gear					General	AUL	.I CAIL	JONI			 			\dashv
Lundi		Bending			ſ		Bend		Grain			Γ-	Ovalized	Г	Pressure/Forced	١
	 	Centre No	nt Concer	ntric to	0/5		BOM/Route		Hardwa	re			Over/Under	tolerance	Temperature/Cure	Ì
	 	Cracks			,		Broken/Damaged		ł	on Incomp	lete		Part Incorred	⊢	Weld	١
		Crushed/0	Crimped.		Ì		Burrs			ions Incom		Unclear	Part Lost/Mi	<u> </u>	Wrong Stock Pulled	
	_	Cuffs			Ì		Contamination		Mainte		.р.о.с,		Part Moved			
		Heat Trea	t		ţ		Countersink		Mislabe			<u> </u>	Positioned V	Vrong		
		Inspection		Tube	•		Cut Too Short		Misread				Power Loss/		Other	
		Ripples in	•				Drill Holes		Offset			L_	J,	·		┨
		Torque W		xtrusio	n		Drawing		ł	Calibration						٦
	Turning Sequence Finish		Out of Sequence						٦							
		Wave/Tw				_	Folio		1	Dimension	ns					٦

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Tuesday, July 24, 2012 7:53:20 AM

Work Order ID:
Parent Item:
Parent Item Name:

AN960JD416

88026

D407-559-115

Purchased

Purchased

No

No

Bearpaw

Start Date: 7/24/2012

Required Date: 7/27/2012

Start Qty: 1.00

510.0000

Required Qty: 1.00

	Location	Loc Oty	Loc Code		
	GA	50			
	116419	50			
	ST357	300			
	122416	300		122416	
	ST359	160			
	117514	51			
	121060	1			
	121541	108		· ·	
NAS1149D0463J Purchased	No	Eac	h 29.0000	12244 JB	
	Location	Loc Qty	Loc Code	<i>y</i>	
	ST351	29			
	116289	8			
	119097	21		<u></u>	

Each

Each

			122416 3	5 12/07/24
Location	Loc Qty	Loc Code	V	. , ,
314	5000		·	
122452	5000			
ST300	1368			
104248	1			
119075	116			
121011	193			
121444	1058		121444	

6,368.0000

DQA:	Date:	

NCR:	Yes /	No	WORK ORE

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date	:
Work Orde	DISPOSITION AGAINST DEPARTMENT/PROCESS										
Part No			Rework Scrap Use-as-is Work Order Update	Scrap Machining Small F Use-as-is Thermoforming Finish		Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other		
INCIV IN	o				Work Order Opdate	¹	carge rab	composite	I	3dphiici [_	
Root				Descri	ption of work order update	order update Initial Action		tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved										•	
onapproved 1		1	i i		F	AULT CATE	GORY		<u> </u>		
Landin	g Gear				General						
	Bending Centre No Cracks Crushed/ Cuffs	Crimped.		o/s	Bend BOM/Route Broken/Damaged Burrs Contamination	Instruct Mainte	ion Incomplete tions Incomplete/ enance	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved	ct issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
-				Countersink Cut Too Short	⊢ ⊣	Mislabeled Misread		Positioned Wrong Power Loss/Surge		Other	
ľ	Ripples in	•			Drill Holes	Offset		L	J	, L	
	Torque W		xtrusion	, [Drawing	Out of	Calibration				
, I	Turning Coguence			╡		Sequence					
	Wave/Tw	ist in Tub	e e	i	lFolio	I Outside	Dimensions				

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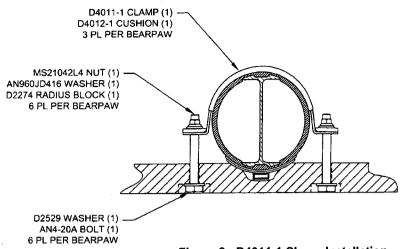


Figure 2 - D4011-1 Clamp Installation

4.0 PARTS LIST

QTY -115	PART NUMBER	DESCRIPTION
X	D407-559-115	BEARPAW INSTALLATION
12	D2274	RADIUS BLOCK
12	D2529	WASHER
2	D2432-3	BEARPAW
6	D4011-1	CLAMP
6	D4012-1	CUSHION
12	AN4-20A	BOLT
12	AN960JD416	WASHER (NAS1149D0463J)
12	MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

BY: D. SHEPHERD (DE # 02)
DATE: 12,07.05

DATE: 12.07.05 CERT. NO.: SH92-17 ISSUE NO.: 7

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN	AP					
CHECKED	P	DRAWING NO.	REV. A SHEET 3 OF 4			
MFG. APPR.	N/A	DSI 9624				
APPROVED	160	TITLE	SCALE			
DE APPR.	#	BEARPAW INSTALLATION	NTS			
DATE 12.0	7.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS TO NOT TO BE USED FOR ANY PURPOSE OF COMMINACATED TO ANY OTHER PERSON WITHOUT				

											DQA.	Date.	
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UPDATE		QA Closed:	Date:	(
Work Order:				DISPOSITION AGAINST DI		AINST DE	EPARTMENT/PROCESS		<i>*</i>				
Part No			Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab Use-as-is Thermoforming Finishing		all Fab nishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other				
Root					Descri	ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data										· · · · · · · · · · · · · · · · · · ·			
Equip/Tooling							ļ						
Operator													
Material													
Setup				:							,		
Other				·									
Process													
Supplier													
Training											Ì		
Unapproved													
						F/	AUL	T CATE	GORY				
Landi	ng (Gear				General						· · · · · · · · · · · · · · · · · · ·	
		Bending				Bend		Grain			Ovalized		Pressure/Forced
 			BOM/Route		Hardware		Over/Under	tolerance	Temperature/Cure				
Cracks			Broken/Damaged		Inspection Incomplete		Part Incorre		Weld				
		Burrs	Т	Instructions Incomplete/Unclear			Part Lost/Mi		Wrong Stock Pulled				
		Cuffs	•			Contamination		Mainte			Part Moved	٠ ـــ	
	Heat Treat		Countersink		Mislabeled		-	Positioned Wrong					

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

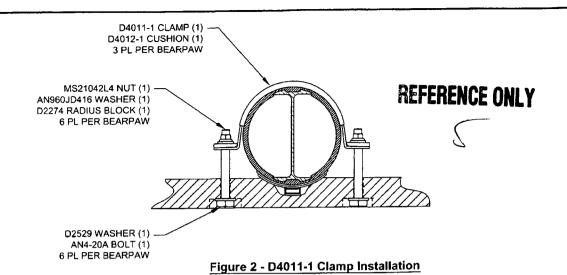
Drill Holes

Drawing

Finish

Folio

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4.0 PARTS LIST

QTY -115	PART NUMBER	DESCRIPTION
>	D407-559-115	BEARPAW INSTALLATION
6 12	D2274/	RADIUS BLOCK
12	-D2529 - 7	WASHER
2	D2432-3 7	BEARPAW
6	D4011-1 Z	CLAMP
76	D4012-1	CUSHION
12	AN4-20A	BOLT
C12	_AN960JD416	WASHER (NAS1149D0463J)
12.	_MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:
D. SHEPHERD (DE # 02)

DATE:
12.07.05
CERT. NO.:
SH92-17
ISSUE NO.:
7

DESIGN AP		DART AEROSPACE LTD					
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA					
CHECKED	P	DRAWING NO.	REV. A				
MFG. APPR.	N/A	DSI 9624	SHEET 3 OF 4				
APPROVED	160	TITLE	SCALE				
DE APPR.		BEARPAW INSTALLATION	NTS				
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